

Date: Monday, 7/9/2007 12:47:08 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	JACK SADDLE
Job Number	33414		
Estimate Number	11177		
P.O. Number	N/A	Part Number	D2281
This Issue	7/9/2007	Drawing Number	D2281 REV G
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	G
Previous Run	33258	Material	N/A
Written By		Due Date	7/30/2007
Checked & Approved By	<i>fb 07.07.09</i>	Qty:	50
Comment	Est Rev:A Est: rev B	Removed from 9 Digit 06.07.17	Um: Each waterjet EC
05-12-02 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
		Comment: Qty.: 0.1313 sf(s)/Unit Total : 6.5625 sf(s) 304SS .080 batch: M105112 → SAD 07108102, (13) <i>HB 07-07-21 (37)</i>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: <i>G</i> Prog Rev: <i>G</i> <i>SAD 07108103</i> 2-Deburr if necessary <i>HB 07-07-21</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>HB 07-07-21</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<i>Er 07108103 (50)</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<i>SAD 07108103 (50)</i>
		Comment: Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 33414

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

8/3 07/08/07 (50)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/07 (X50)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11 07/08/07 (50)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11 07/08/08 (50)

Job Completion



JJ 07-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33414
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HS
Date:	07-07-21

Audited by:	✓
Date:	07/08/03

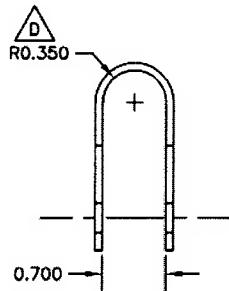
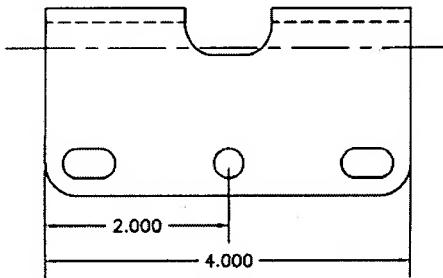
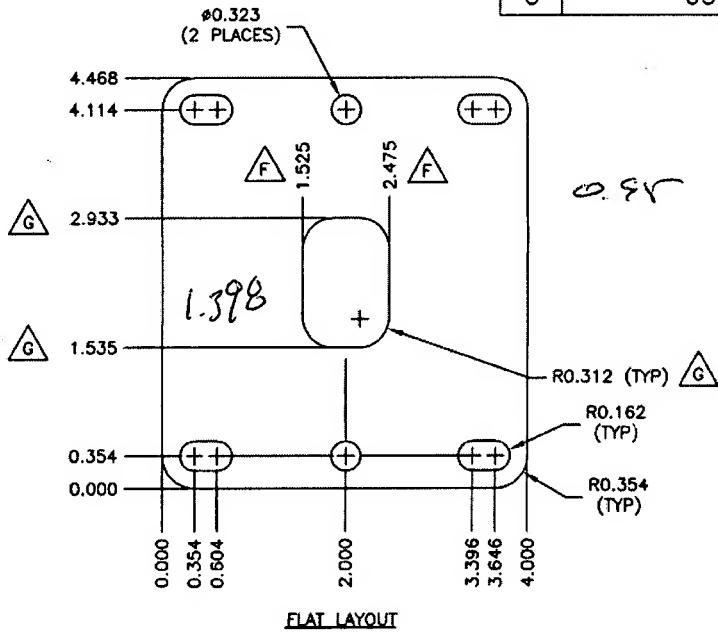
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN BW	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CP</i>	APPROVED <i>WJ</i>	DRAWING NO. D2281	REV. G	SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE		
B	94.10.18	DIMENSION WAS 2.878		
C	94.11.04	ADD TOOLING NOTCH		
D	98.03.27	R0.350 WAS R0.280		
E	04.11.18	REMOVE TOOLING NOTCHES		
F	05.03.16	REDESIGN FLAT PATTERN		
G	05.06.07	REDESIGN FLAT PATTERN		

RELEASED
05/08/11



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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